



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4681-3

Job Sheet 176971



Part No: D4681-3

Job Qty: 24 ea

DAS
21
9-89

Part Name: Doubler



Part Weight: 0 lbs

Status: Scheduled

Priority: **High**

Job Created: 5/3/18

Job Tracking No:

Created By: Michelle Gagnon-Donovan

Due Date: 5/14/18

Description:

Type: **AGG**

Note: DWG REV B SHEETS 3,4 IPP REV:A 13.09.23 NEW ISSUE DD VERF:JFS IPP REV:B 13.11.14 AS PER
DWG REV.B DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	24 Ea	5/14/18	5/14/18	0.00	0.00	Start Up Waterjet		SC 18/05/18
100	Waterjet	24 pcs	5/14/18	5/14/18	0.00	4.97	Waterjet1		SC 18/05/18
110	QC	24 pcs	5/14/18	5/14/18	0.00	0.00	QC2 Waterjet-3		SC 18/05/18
120	QC	24 pcs	5/14/18	5/14/18	0.00	0.00	QC8-5		38
130	Brake NC	24 pcs	5/14/18	5/14/18	0.00	1.58	Brake NC 1		9-89 DAS
140	QC	24 pcs	5/14/18	5/14/18	0.00	0.00	QC5		38
150	HandFinish	24 pcs	5/14/18	5/14/18	0.00	1.98	HandFinish1		SA 18/06-21
160	QC	24 pcs	5/14/18	5/14/18	0.00	0.00	QC7-4		38
170	Packaging	24 pcs	5/14/18	5/14/18	0.00	0.00	Packaging3-2		9-89
180	QC21-SA	24 Ea	5/14/18	5/14/18	0.00	0.00	QC21		DAS 21 9-89

Part Op 100 - 1-Cut as per Dwg Dwg Rev: **B** Prog Rev: **B** 2-Deburr if necessary
 Descriptions: 110 - QC2- Inspect parts off machine FAI/FAIB
 120 - QC8- Inspect parts - second check
 130 - Form as per dwg
 140 - QC5- Inspect part completeness to step on W/O
 150 - Chemical Conversion Coat per QSI005 4.1
 160 - QC7-Inspect Chemical Conversion Coat
 170 - Identify as per dwg & Stock Location: LOCATION : LG001
 180 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6S.063	6061-T6 .063 Sheet	1.9200 sf (.08 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6S.063	2	181	0

Part Specifications

Specifications could not be found.



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Container No: S071267



Part: D4681-3

Job No: 176971

Serial No/Batch: S071267

Revision:

Inspector:

Date: 05/14/16

51

38

38

51

